

5108

DART AEROSPACE LTD	Work Order:	22322
Description: 350 Skidtube Web	Part Number:	D2739
Drawing: D2739 Rev B	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller RF 03.05.12 Dwg NOT REQUIRED	DP	05.01.26	4
2	LG	Pick: Qty Part Number Description Batch 1 D2600-5 Web B12433	DP	05-2-3	4
3	LG	Cut D2600-5 to length as per Dwg D2739.	DP	05-2-3	4
4	LG	Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	DP	05-2-3	4
5	LG	Use uni-bit to open holes to finish size as per Dwg D2739.	DP	05-2-3	4
6	LG	Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.	DP	05-2-3	4
7	FP	Acid Etch and Alodine per QSI 005 4.1	DP	05-2-15	4
8	LG	Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.			
9	QC5	Inspect for completeness on the W/O	DP	05-03-02	4
10	LG	Identify and Stock using a lead free paint pen	DP	05-3-2	4
11	AC	Cost / part ZY.47	SAC	05.03.03	4
12	DC	Close W/O ZY.47 Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	99.01.04	Drawing to Rev. B	DM	
C	02.11.28	Reformat	KJ / RF RF	

RELEASED
02/11/29 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No	:	0022322	Department Code:		
Project Name	:	D2739	Burden Flags	:	NNNNNNN
Project For	:	WK508	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2739	Invoice Number	:	
Description	:	350 I Beam	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	4	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	01-25-05	Est Margin	:	0.000%
Est Finish Date	:	02-20-05	Actual Margin	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Burden	:	0.00	0.00	0.00	
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00

Dan Stow

From: "David Shepherd" <davids@dartaero.com>
To: "Dan Stow" <dans@dartaero.com>
Sent: February 14, 2005 12:07 PM
Subject: Re: 350 skid tube webs

Dan

Because of the blade fitting, I think this would be an acceptable deviation.
Attach a copy of this email to the work order as evidence that I agree that you can use these webs.

David

----- Original Message -----

From: Dan Stow
To: David Shepherd
Sent: Tuesday, February 08, 2005 12:02 PM
Subject: 350 skid tube webs

David

The webs for the 350 tubes are tapered at the fwd end for 1" max. B#22322 webs were tapered at the wrong end. Is it acceptable to taper the correct end and still use these webs?

Dan